

Work Order ID 83722

83722

Page 1

April-24-12 11:12:58 AM

Item ID: D3210-1B

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 4/24/12 Start Qty: 11.00

11

Cust Item ID:

Required Date: 4/24/12 Req'd Qty: 11.00

11

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3210

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3210 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

2024 0.080

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

11 Ø SA/Jm
12-4-24

11 Ø SA/Jm
12-4-24.

8/26/15

(40)

Work Order ID 83722

April-24-12 11:12:58 AM

83722

Page 2

Item ID: D3210-1B

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 4/24/12 Start Qty: 11.00

11

Cust Item ID:

Required Date: 4/24/12 Req'd Qty: 11.00

11

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

130

Small Fab

Small Fab

0.00

Small Fab

Memo
Deburr

0.00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

⑪ 7/6 12-4-25

Work Order ID 83722

April-24-12 11:12:58 AM

83722

Page 3

Item ID: D3210-1B

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 4/24/12 Start Qty: 11.00

11

Cust Item ID:

Required Date: 4/24/12 Req'd Qty: 11.00

11

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

10:00

11X

Ø

M-L

12/04/26

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

11 Ø

124-26

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Packaging

Memo

0.00

12/4/27 (11)

Work Order ID 83722

April-24-12 11:12:59 AM

83722

Page 4

Item ID: D3210-1B

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 4/24/12 Start Qty: 11.00

11

Cust Item ID:

Required Date: 4/24/12 Req'd Qty: 11.00

11

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC21- Final Inspection - Work Order Release

0.00


190

QC

Memo

0.00

Quality Control

12/4/30 
1120427

Picklist Print

April-24-12 11:12:58 AM

Work Order ID: 83722
Parent Item: D3210-1B
Parent Item Name: Doubler

Start Date: 4/24/12
Start Qty: 11.00
Required Date: 4/24/12
Required Qty: 11.00

Comments: IPP revA 11.06.07 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No				sf	251.8000		5.83			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	251.8	
105411	6	
109424	4	
110347	0.5	
112331	3	
113796	5	
114025	10.7	
116604	5.8	
117392	19.1	
118180	46	
119117	25.7	
120989	126	

120989

SJ/Jm
12-4-29

8 7 6 5 4 3 2 1

D

D

C

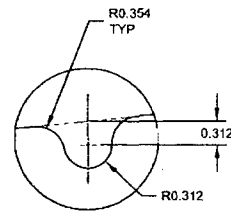
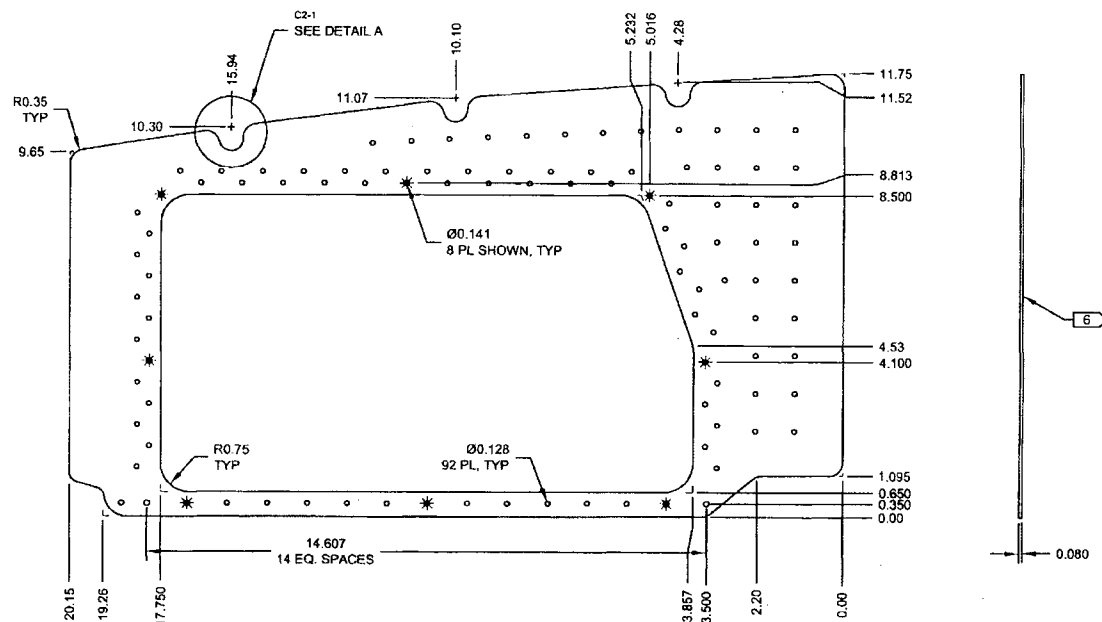
C

B

B

A

A



DETAIL A
SCALE 2X, 3 PL D7-1

D3210-1 DOUBLER

D3210-1 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "BLACK SANDETEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3210-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.86 lbs
- 8) MAKE PER "D3210-1_REV8.DXF"

w/0 83722

RELEASED
2011-06-14

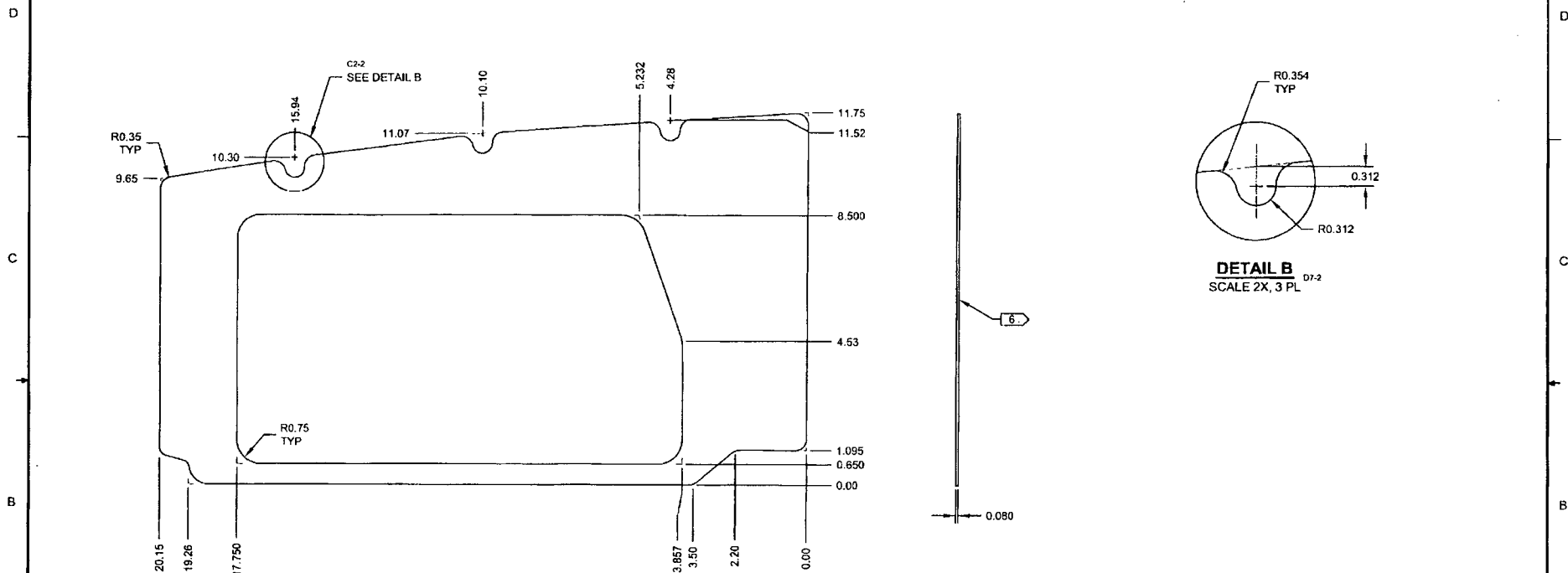
B	FORMAT TO CURRENT STD; ADD D3210-1B. REASON: PAR11-109.	MB	11.06.03
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3210-1
TITLE DOUBLER
REV. B
SHEET 1 OF 2
SCALE
NTS

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8 7 6 5 4 3 2 1



D3210-1B BLANK DOUBLER

D3210-1B NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3210-1B" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.87 lbs
- 8) MAKE PER "D3210-1B_REV.B.DXF"

RELEASED
2011-06-10

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3210	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
DATE	11.06.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries